

Date: Wednesday, 9/12/2007 12:13:14 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-------------------------|-------------------------------------|--------------------|-------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | WEARSHOE |
| Job Number : | 34597 | | |
| Estimate Number : | 10615 | | |
| P.O. Number : | N/A | Part Number : | D265623 |
| This Issue : | 9/12/2007 | S.O. No. : | N/A |
| Prsht Rev. : | NC | Drawing Number : | D2656 REV D |
| First Issue : | N/A | Project Number : | N/A |
| Previous Run : | 34171 | Drawing Revision : | D |
| | | Material : | N/A |
| Written By : | | Due Date : | 9/24/2007 |
| Checked & Approved By : | | Qty: | 40 |
| Comment : | Est: 02.10.25 Re-format KJ | Um: | 20 |
| | | Each | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------|-------------------------|
| 1.0 | M1010S20GA | 1010/1025/A21/6aA SHEET |
|-----|------------|-------------------------|



Comment: Qty.: 1.4800 sf(s)/Unit Total : 29.5995 sf(s)
 1018 20 GA .040" THK
 Batch: M105671 HB 07-09-20

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: D HB 07-09-20
 Prog Rev: D

2-Deburr if necessary HB 07-09-20

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

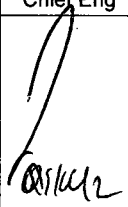
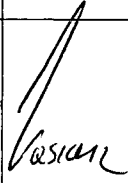
| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326
 2-Form joggle as per Dwg D2656 using Jig DT8158
 3-Identify as D2656-23

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/07/28
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|----------|----------|---|--|---------------------------------|-----------|----------------|---------------------------|--|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
| 07/07/21 | H 2.0 | one part sensor small cutout in the Top for the Bolt. R.C. pressure was in the |  | Scrap and and Replace | Destroy | 07-08-21 | Er 07/07/21 |  | Er 07/07/21 |
| | | tube for water jet and it moved to a different location | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 34597

Part Number: D265623

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

En 07/09/25 (40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

MJ 07-09-27

(40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/09/26 (40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-18

FL 07/09/27

(40)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DG 07/09/28

Job Completion



U 07-09-28

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|------------------------------|--|--------------|----------|
| DART AEROSPACE LTD | | Work Order: | 34597 |
| Description: Wearshoe | | Part Number: | D2656-23 |
| Inspection Dwg: D2656 Rev: D | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 52.850 | +/-0.010 | 52.850 | * | | | |
| 48.200 | +/-0.010 | 48.200 | * | | | |
| 44.700 | +/-0.010 | 44.700 | * | | | |
| 39.310 | +/-0.010 | 39.310 | * | | | |
| 33.920 | +/-0.010 | 33.920 | * | | | |
| 28.530 | +/-0.010 | 28.530 | * | | | |
| 23.140 | +/-0.010 | 23.140 | * | | | |
| 17.750 | +/-0.010 | 17.750 | * | | | |
| 14.250 | +/-0.010 | 14.250 | * | | | |
| 9.500 | +/-0.010 | 9.500 | * | | | |
| 4.750 | +/-0.010 | 4.750 | * | | | |
| 2.000 | +/-0.010 | 2.000 | * | | | |
| 2.000 | +/-0.010 | 2.000 | * | | | |
| 1.885 | +/-0.010 | 1.884 | * | | | |
| 0.300 | +/-0.010 | .294 | * | | | |
| 0.300 | +/-0.010 | .298 | * | | | |
| 0.040 | +/-0.010 | .041 | * | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

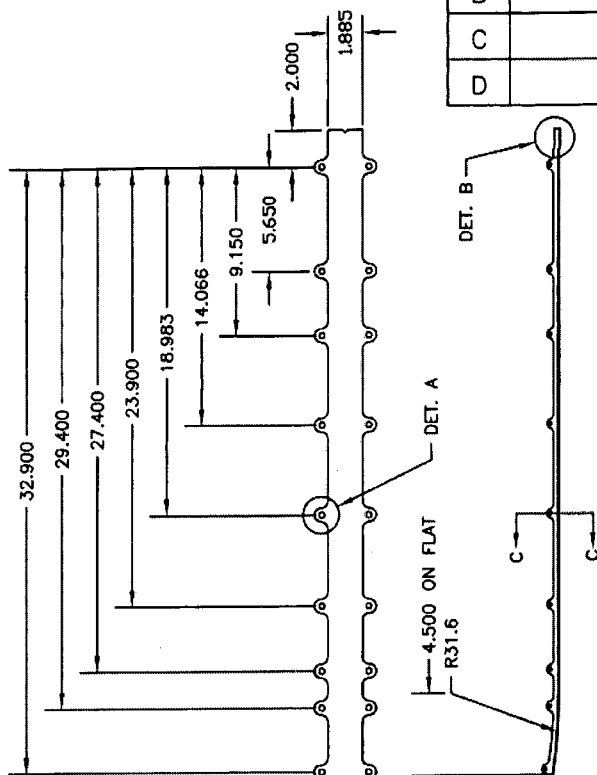
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|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | JB | Audited by: | En | Prototype Approval: | N/A |
| Date: | 07-09-20 | Date: | 11/02/21 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.07.18 | New Issue | KJ/JLM | JB |

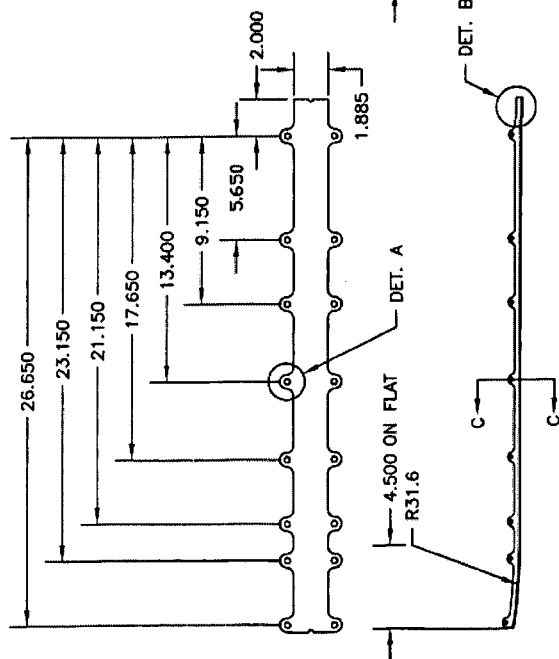


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|---------|--------------------|----------------------------------|--------------------|--------------------------|
| DESIGN | DS | DRAWN BY | CP | DART AEROSPACE USA, INC. |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | PORT HADLOCK, WA |
| DATE | 05.08.17 | DRAWING NO. | D2656 | REV. D |
| | | | | SHEET 1 OF 4 |
| | | TITLE | WEARSHOE | SCALE |
| | | | | 1:10 |
| A | 97:03:25 | NEW ISSUE | | |
| B | 97:06:02 | CHANGED TABS | | |
| C | 97:06:26 | R31.6 WAS R19.5 | | |
| D | 05.08.17 | ENLARGE ALL HOLES TO IMPROVE FIT | | |

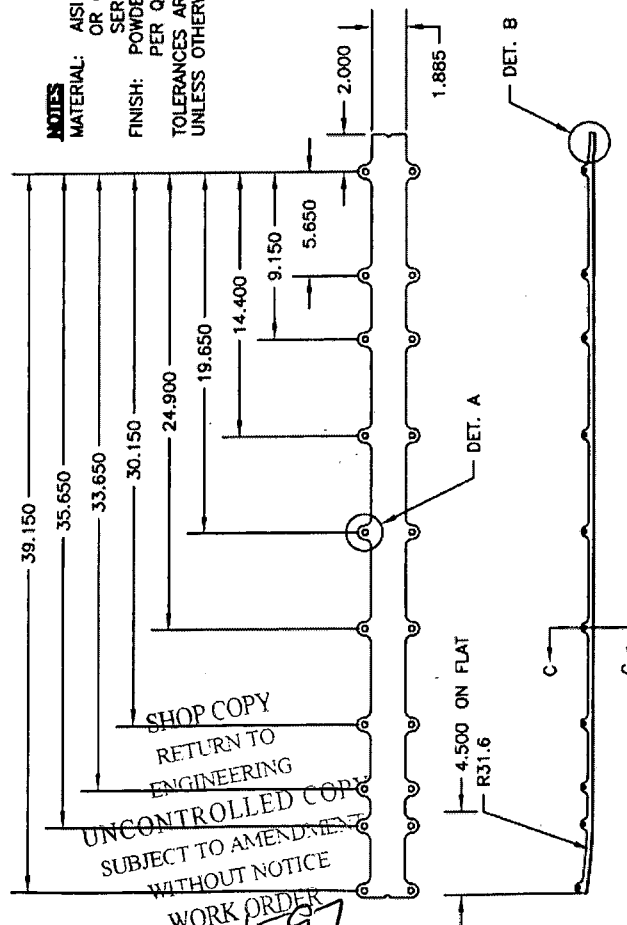
D2656-13



D2656-11



D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08

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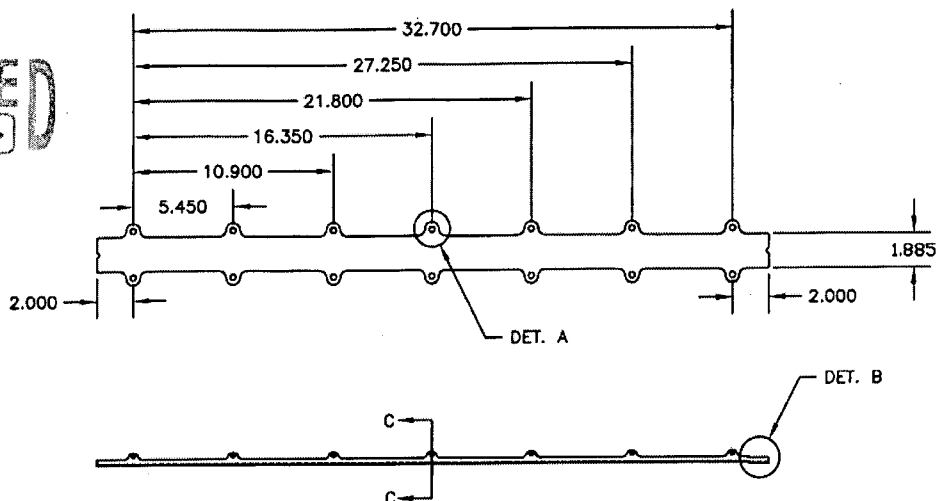
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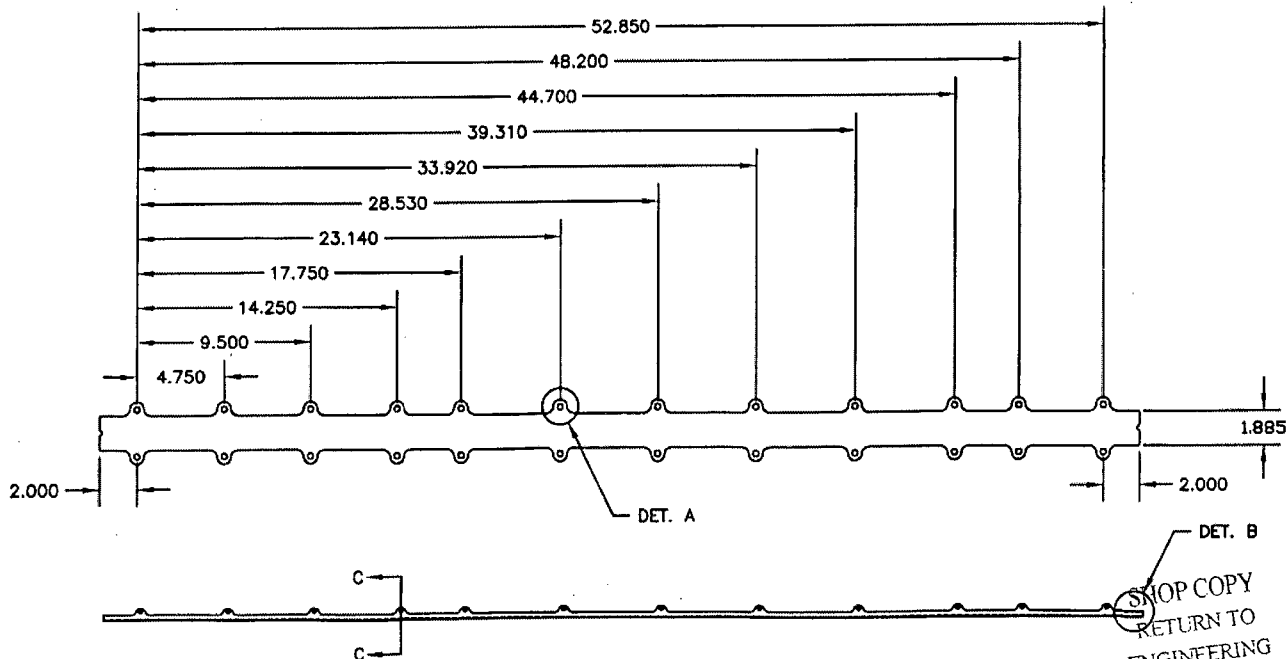
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| DATE 05.08.17 | TITLE WEARSHOE | | SCALE 1:10 |

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D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
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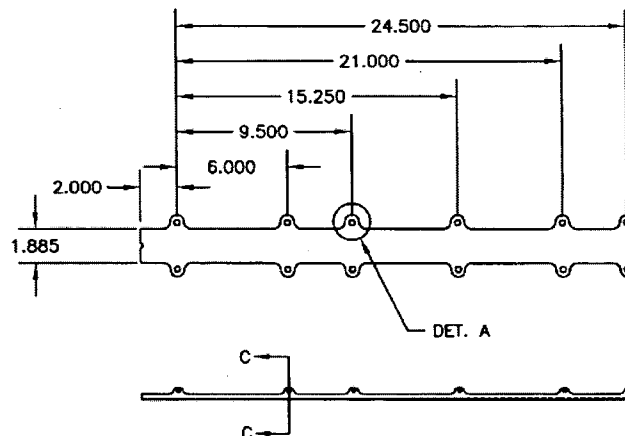
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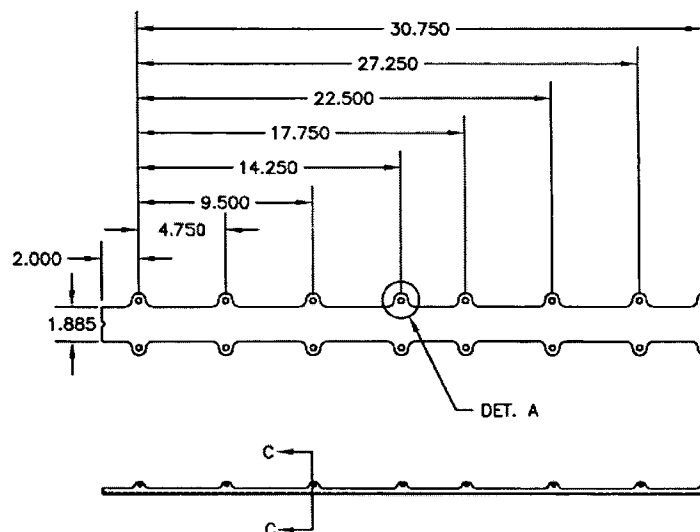
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| | | TITLE | WEARSHOE | SHEET 3 OF 4 |
| | | SCALE | 1:10 | |

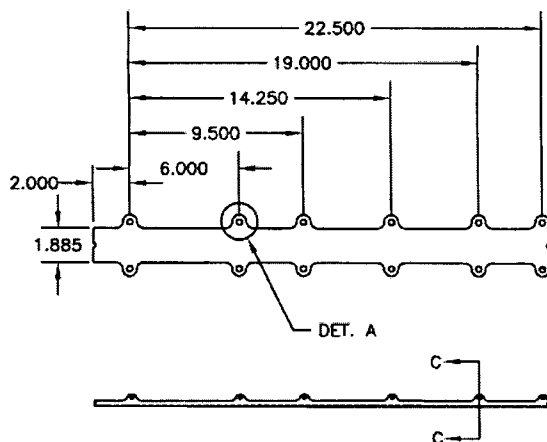
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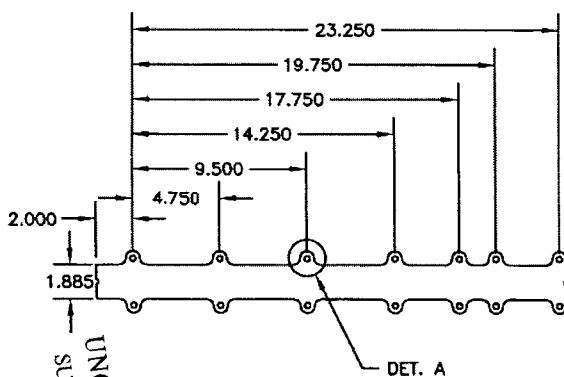
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D2656-31



D2656-35



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TOLERANCES ARE PER DART QSI 018
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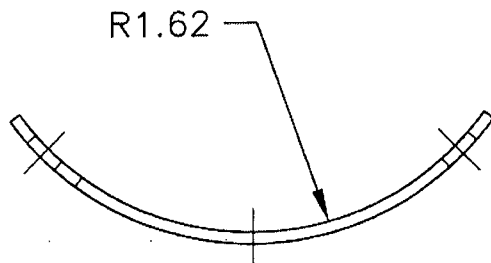
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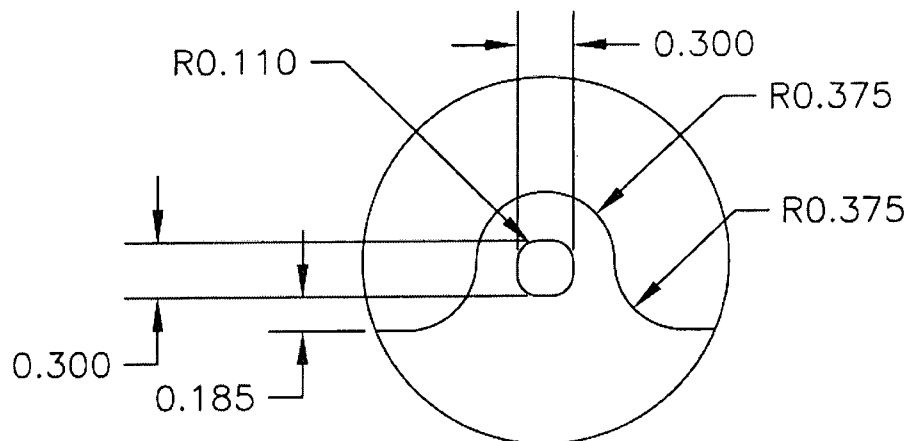
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| DATE 05.08.17 | | TITLE WEARSHOE | SCALE 1:10 |

SECTION C-C

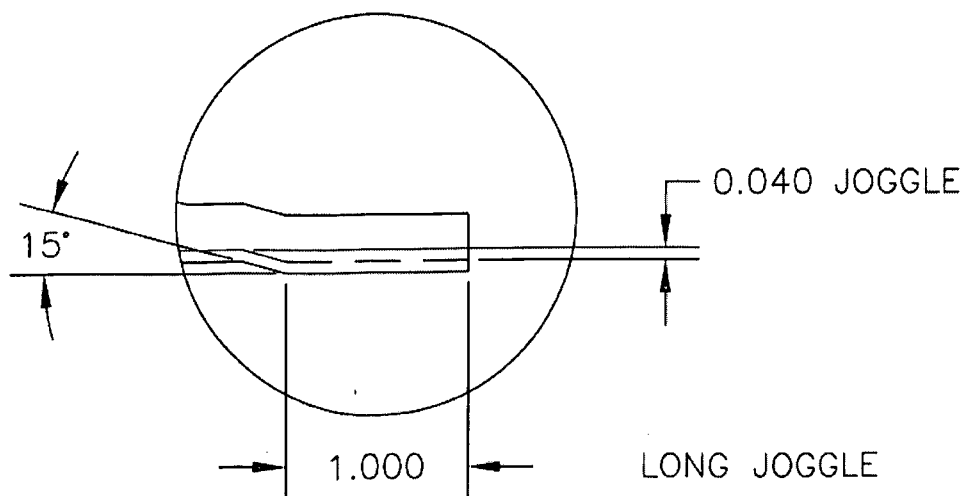


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DETAIL B



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